

ABSTRACT

A shuttle feed passage 7 is provided in each functional processing station
5 from a coating booth 1 to an after-heating booth 6 for performing a series of
operations from coating to baking and drying. A conveyance frame 12 is fed to each
of the booths 1 - 6 using a shuttle feed method, and conveyance of the workpiece W is
stopped to perform the coating operation and the like. An empty conveyance frame 12
from which the coated workpiece W is removed is circulated through a self-propelled
10 feed passage 9. A carriage 39 of the conveyance frame 12 is caused to travel outside
the booth 1, and the supporting arm 13 of the conveyance frame 12 is caused to travel
inside the booth, wherein the supporting arm is caused to rotate around the axis.